

Work Order ID 65725

Monday, January 24, 2011 1:35:31 PM



Page 1

Item ID:	D206-628-032	Accept		Setup	Start	
Revision ID:						
Item Name:	Heli-Access-Step RH				Stop	
Start Date:	1/24/2011	Start Qty: 2.00		Cust Item ID:		
Required Date:	2/7/2011	Req'd Qty: 2.00		Customer:		
Reference:						

Approvals:	Process Plan:		Date:	11-01-24	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
N/A	Rev N/A								
100		0.00							
	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy blue file and type labels as per PPP D206-628-032 CHG 003								
110	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00							
Quality Control									

Sulozlay

PS 11-01-24

11/13/25 (20)

8/11/03/04

x2
R4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65725

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Page 2

Item ID: D206-628-032

Accept

Revision ID:

Item Name: Heli-Access-Step RH

Start Date: 1/24/2011 Start Qty: 2.00

Required Date: 2/7/2011 Req'd Qty: 2.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-628-032								
	Location: <u>11E</u>								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

ME
11-03-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 65725

Parent Item: D206-628-032

Parent Item Name: Heli-Access-Step RH



Start Date: 1/24/2011

Required Date: 2/7/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM
IPP Rev:E as per ecn 1118 08-02-05 DD verified by:EC IPP Rev:F
as per chg 003 DD 10.02.25 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-13A Bolt		Purchased	No			110	Each	419.0000	4	8		11/3/28	
---------------------	--	-----------	----	--	--	-----	------	----------	---	---	--	---------	--

Location	Loc Qty	Loc Code
----------	---------	----------

ST357	419	
-------	-----	--

116191	7	
--------	---	--

116669	412	
--------	-----	--

AN4-14A Bolt		Purchased	No			110	Each	121.0000	4	8		11/6/06 11/3/28	
---------------------	--	-----------	----	--	--	-----	------	----------	---	---	--	-----------------	--

Location	Loc Qty	Loc Code
----------	---------	----------

ST357	1	
-------	---	--

114752	1	
--------	---	--

ST358	5	
-------	---	--

110372	2	
--------	---	--

113359	3	
--------	---	--

t357	115	
------	-----	--

116419	115	
--------	-----	--

AN4-15A Bolt		Purchased	No			110	Each	51.0000	4	8		11/6/06 11/3/28 SD 120	
---------------------	--	-----------	----	--	--	-----	------	---------	---	---	--	------------------------	--

Location	Loc Qty	Loc Code
----------	---------	----------

ST358	51	
-------	----	--

114784	9	
--------	---	--

115108	5	
--------	---	--

115936	37	
--------	----	--

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, January 24, 2011 1:35:38 PM

Work Order ID: 65725

Parent Item: D206-628-032

Parent Item Name: Heli-Access-Step RH

Start Date: 1/24/2011

Required Date: 2/7/2011

Start Qty: 2.00

Required Qty: 2.00

AN960JD416

NAS1149D0463J

Purchased

No

110

Each

30.0000

12

24



Washer



M116805 11/3/25

Location

Loc Qty

Loc Code

ST300

24

113288

24

ST356

6

115622

6

D2724-042

Manufactured

No

110

Each

0.0000

1

2



206L Step Assembly

D2731-3

Manufactured

No

110

Each

134.0000

4

8



Mounting Lug



B65727 11/3/25

Location

Loc Qty

Loc Code

ST469

134

37335

8

47967

79

52329

39

9113

3

9442

5

D2732-030

Manufactured

No

110

Each

0.0000

8

16



Rubber Cushion



B56516 11/3/25

x8 per kit @ 30" long → measure 8" x 10" hole

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, January 24, 2011 1:35:39 PM

Work Order ID: 65725

Parent Item: D206-628-032

Parent Item Name: Heli-Access-Step RH

Start Date: 1/24/2011

Required Date: 2/7/2011

Start Qty: 2.00

Required Qty: 2.00

D3394-041

Manufactured No

110

Each

60.0000

4

8



Lug Assembly



11/3/20

Location

Loc Qty

Loc Code

ST474

60

34833

4

47970

12

53446

4

56528

40

8

MS21042L4

Purchased No

110

Each

4,368.000

12

24



Nut



11/3/20 SP

20

Location

Loc Qty

Loc Code

ST300

4368

1123143

2

115589

10

115621

21

116188

3500

116548

835

24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.1 D206-628-011/-012/-021/-022/-031/-032 REGULAR DART HELI-ACCESS- STEPS™ PARTS LIST

Qty -011	Qty -012	Qty -021	Qty -022	Qty -031	Qty -032	Part Number	Description
X						D206-628-011	206 A/B STEP INSTALLATION LH
	X					D206-628-012	206 A/B STEP INSTALLATION RH
		X				D206-628-021	206 L/L1/L3/L4 STEP INSTALLATION LH
			X			D206-628-022	206 L/L1/L3/L4 STEP INSTALLATION RH
				X		D206-628-031	407 STEP INSTALLATION LH
					X	D206-628-032	407 STEP INSTALLATION RH
1						D2721-041	STEP ASSEMBLY LH
	1					D2721-042	STEP ASSEMBLY RH
		1		1		D2724-041	STEP ASSEMBLY LH
			1		1	D2724-042	STEP ASSEMBLY RH
2	2			4	4	D2731-3	MOUNTING LUG
2	2	4	4			D2731-7	MOUNTING LUG
8	8	8	8	8	8	D2732-030	RUBBER CUSHION
2	2			4	4	D3394-041	MOUNTING LUG
2	2			4	4	*D3394-1	*MOUNTING LUG
4	4			8	8	*MS35489-93	*GROMMET
2	2	4	4			D3394-043	MOUNTING LUG
2	2	4	4			*D3394-3	*MOUNTING LUG
4	4	8	8			*MS35489-93	*GROMMET
4	4			4	4	AN4-13A	BOLT
4	4	4	4	4	4	AN4-14A	BOLT
4	4	8	8	4	4	AN4-15A	BOLT
12	12	12	12	12	12	AN960JD416	WASHER
12	12	12	12	12	12	MS21042L4	NUT (OR MS21042-4)

*DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE

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Page 1

Item ID: D206-628-032

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step RH

Start Date: 1/24/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 2/7/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

PS

Date: 11-01-24 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

N/A

Rev N/A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels as per PPP D206-628-032 CHG 003

PS 11-01-24

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

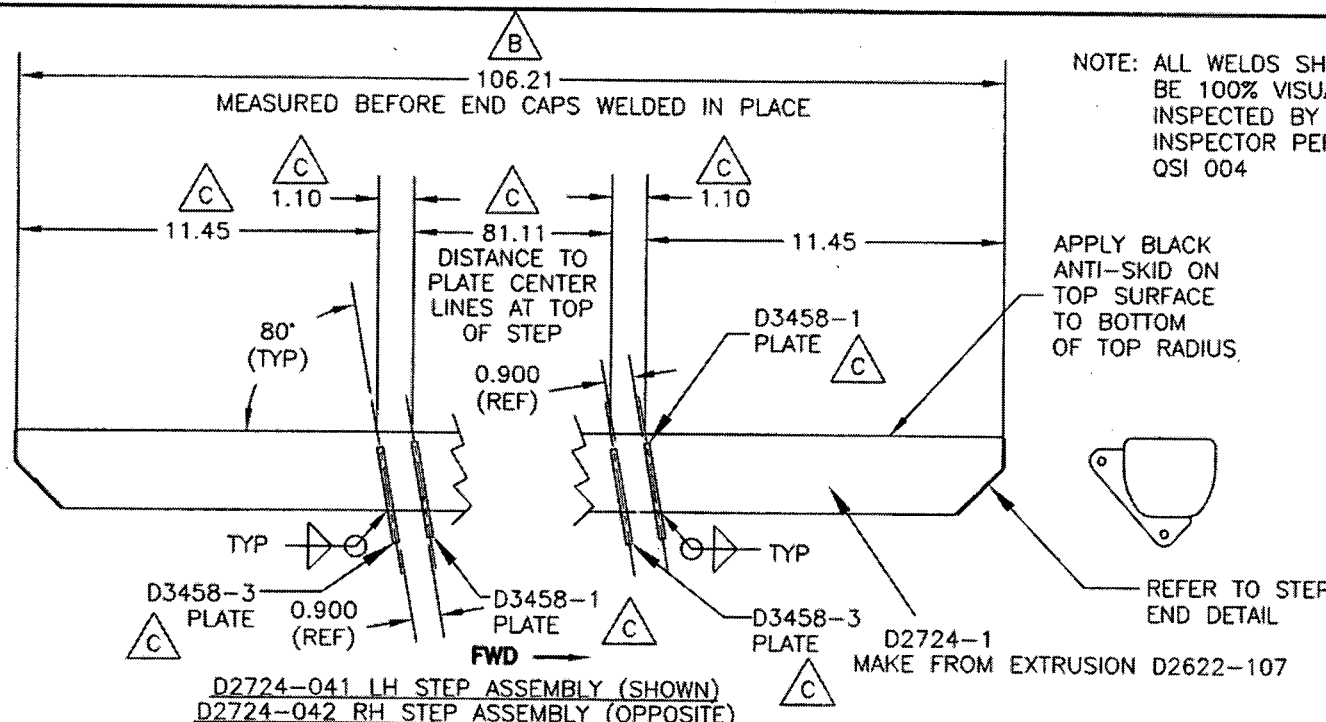
Quality Control

DART

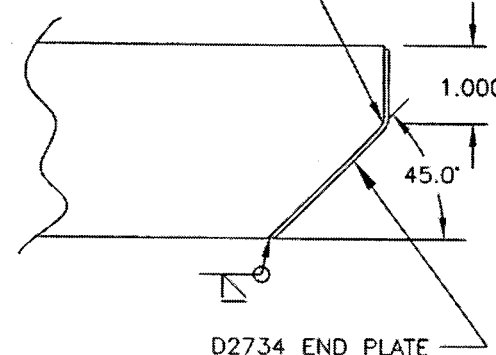
RELEASED
05.11.14

DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	05.09.19			
	A	97.12.04		206L/407 STEP ASSEMBLY
	B	98.10.19		UPDATED WELD DETAIL REVISED TOLERANCES
	C	05.09.19		RE-DESIGN, ADD D3458-1/-3
				SCALE
				NTS
				SHEET 1 OF 1
				REV. C

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004



ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042		
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

D2724-041/-042 STEP ASSEMBLY

- MAKE FROM EXTRUSION D2622
- WELD PER DART QSI 004
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- ALL DIMENSIONS ARE IN INCHES
- ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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REFERENCE ONLY